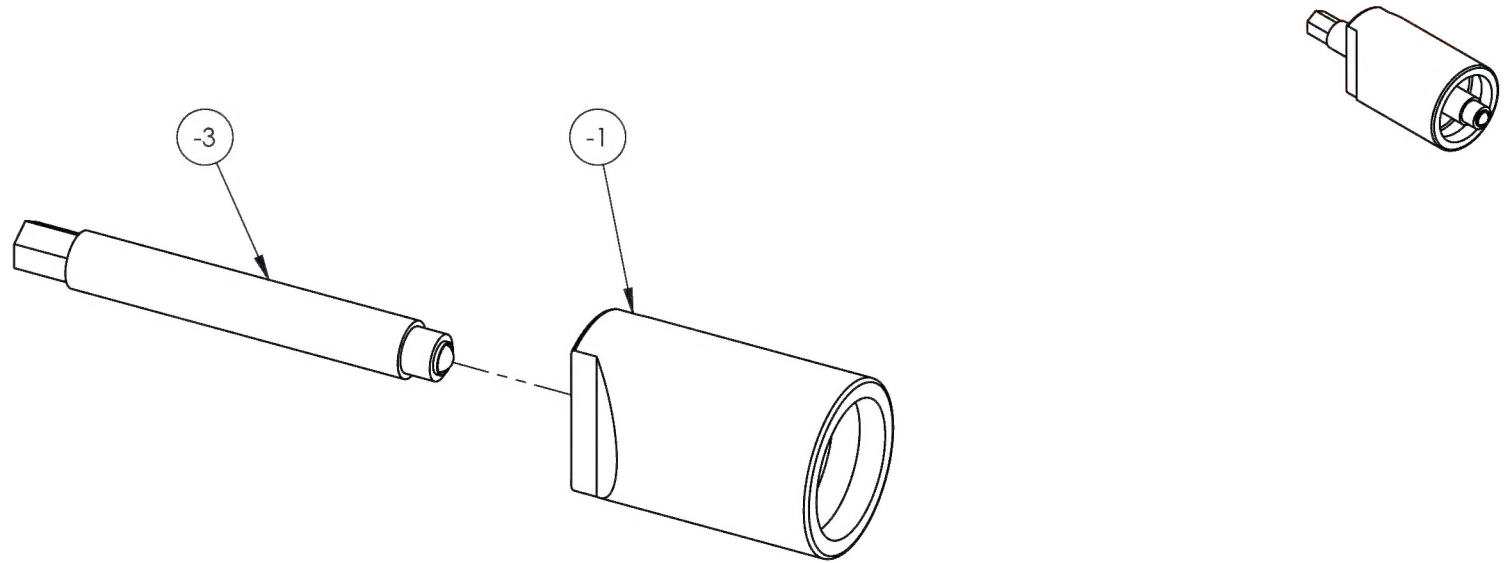


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	9/12/2016	rjc	JAG

SEE ATTACHED DEVIATION



NOTE:
REF. EUROCOPTER T/N 1X56-122-276.

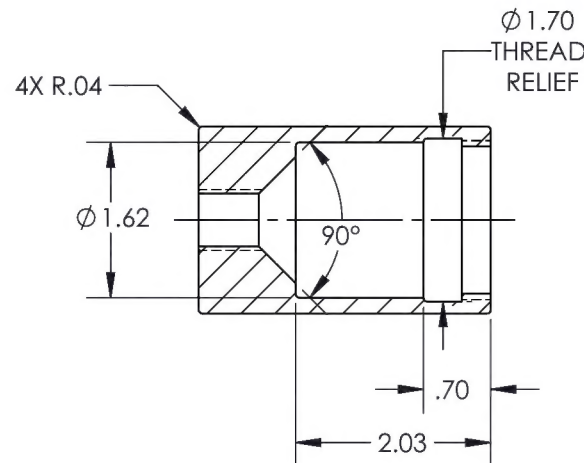
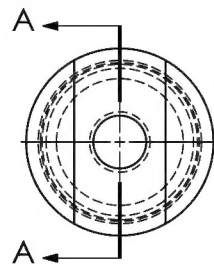
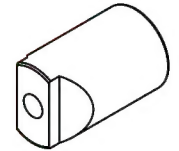
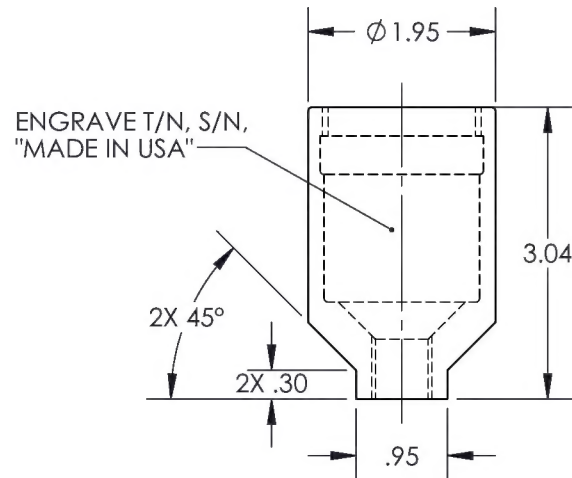
DART AEROSPACE	
TITLE PULLER	
DWG NO. RBE1X56-122-276	REV 1
MAT'L REAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH CHECKED: DUERFELDT OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
USED ON MODEL EC145	
SCALE 1:2	DATE 7/13/2016
SHEET 1 OF 4	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	HOUSING	4140/4142		2
	X		-3	1	BOLT ASSEMBLY			3
	1		-5		BOLT	4140/4142		4
	1	B/O	-7		BALL	S2 TOOL STEEL	Ø5/16 (MCMASTER-CARR #1995T13)	3
	ASSY -3							

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED

SEE ATTACHED DEVIATION



SECTION A-A

M42 X .8 -6H ∇ .30

M16X2.0 - 6H
THRU ALL



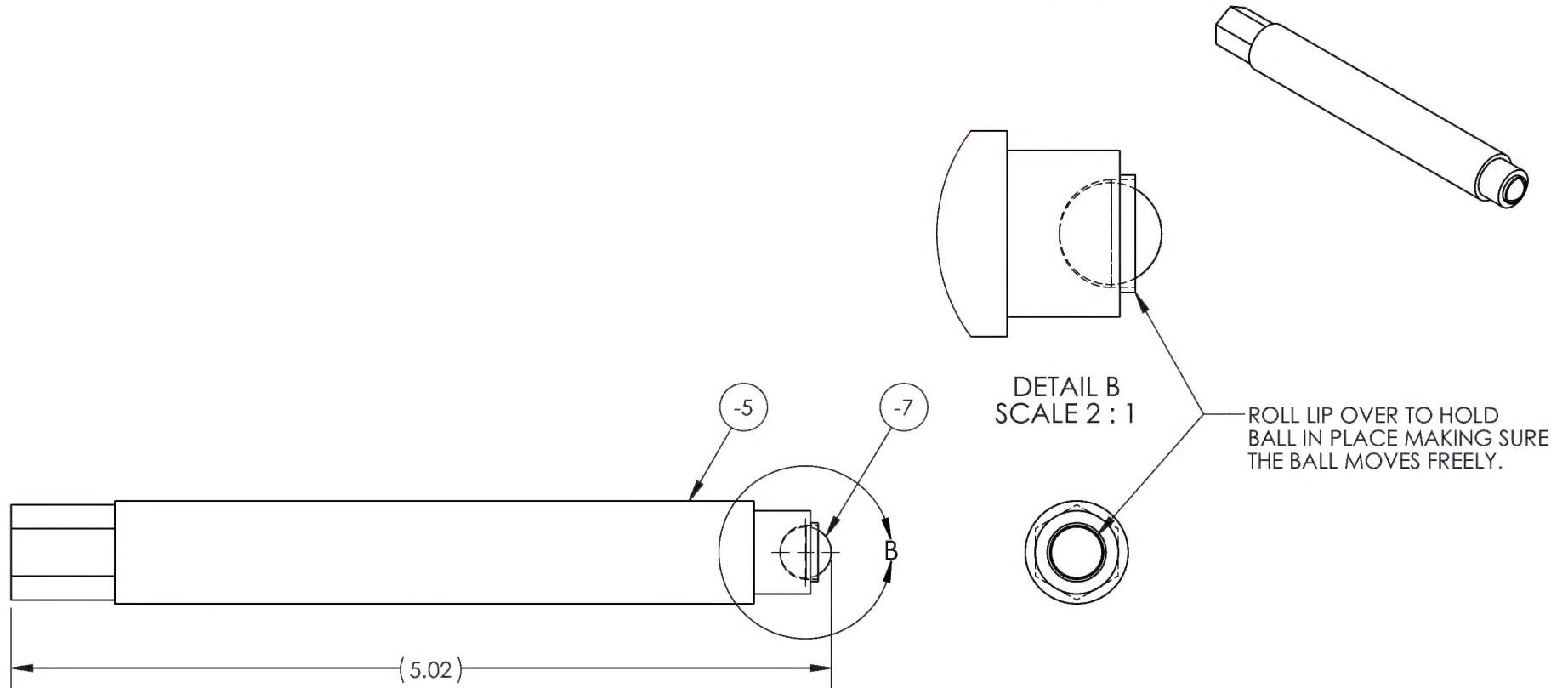
TITLE		PULLER	
DWG NO.	RBE1X56-122-276-1		REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED		
HEAT RC 28-32	DIMENSIONS ARE IN INCHES		
TREAT	.XXX \pm .005 FRACTIONS \pm 1/8		
FINISH ZINC PLATE	.XX \pm .01 ANGLES \pm 5°		
SPEC ASTM B633 TYPE I SC 2	.X \pm .1 SURFACES = 125°		
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES		
CHECKED: DUERFELDT	.015 x 45° OR .015R		
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY		
QA APPR: LINDSAY	AFTER PLATING		
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER		
SCALE 1:2	DATE 7/13/2016	USED ON MODEL	
		H145	
		SHEET 2 OF 4	

①
HOUSING

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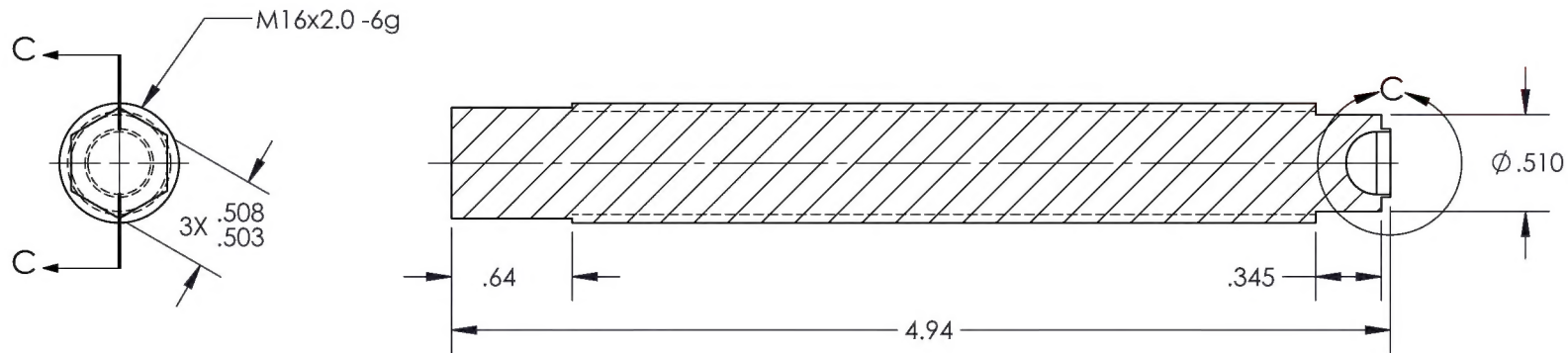
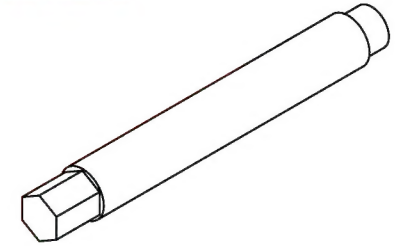
(3)
BOLT ASSEMBLY

DART AEROSPACE	
TITLE PULLER	
DWG NO. RBE1X56-122-276-3	REV 1
MAT'L TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EC145
SCALE 1:1	DATE 7/13/2016
SHEET 3 OF 4	

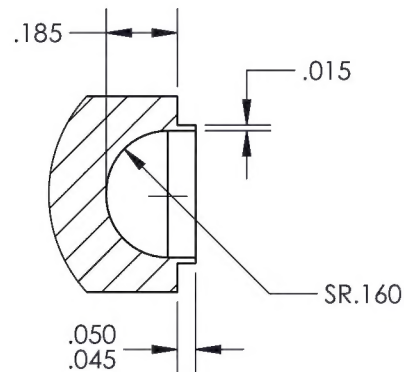
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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

SEE ATTACHED DEVIATION



SECTION C-C



DETAIL C
SCALE 2 : 1

(-5)

BOLT

DART AEROSPACE	
TITLE: PULLER	
DWG NO. RBE1X56-122-276-5	REV 1
MAT'L 4140/4142 HEAT TREAT RC 28-32 FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH	USED ON MODEL
CHECKED: DUERFELDT	EC145
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:1	DATE 7/13/2016
SHEET 4 OF 4	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. <u>RBE1X56-122-276-5</u> <u>REV. 1</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (OS1042) 	
Description Work Order Deviation			Disposition		
ADDED THREAD RELIEF BETWEEN 0.508 - 0.503 HEX AND M16x2.0 -6g THREAD ADDED 0.04 x 45.0° CMF TO END OF 0.508 - 0.503 HEX			THIS DEVIATION IS ACCEPTABLE THE FIT, FORM, AND FUNCTION OF THE PART WILL BE AS ORIGINALLY INTENDED		
			Completed By _____		
			Lead hand / Supervisor _____		
			QC / QA Coordinator _____		
Root Cause <div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input checked="" type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
		Other/Details: _____ _____ _____			